

Date: Wednesday, 2/15/2006 3:50:33 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG BRACKET		
Job Number	: 25867					
Estimate Number	: 10010					
P.O. Number	: N/A		Part Number	: D27353		
This Issue	: 2/15/2006	S.O. No. : N/A	Drawing Number	: D2735 REV C		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: C		
Previous Run	: N/A		Material	: N/A		
Written By	<u>See Comment Below</u>		Due Date	: 3/10/2006		
Checked & Approved By	<u>skf 06.02.16</u>			Qty:	20	Um: Each
Comment	: Est Rev:C Removed from 9 Digit 05-10-25		JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING Comment: PURCHASING Issue P/O: <u>603</u> E-mail or Ship DXF file to vendor Laser cut flat pattern as per Dwg D2735 Possible supplier: Ind. Laser Material realease note is required.
2.0	D2735F	Lug Bracket Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Lug Bracket
3.0	PACKAGING 1	PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached
4.0	QC6	DIMENSIONAL CHECK Comment: DIMENSIONAL CHECK Inspect dimensions per templates D2735-3T1 & DWG D2735
5.0	BRAKE NC	NC BRAKE Comment: NC BRAKE 1-Form D2735-1 as per Dwg D2735. Use CNC Brake Jig DT8204 2-Deburr if required.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-03-14	4	<ul style="list-style-type: none"> - Took 1 per template D2753-3T1 (Identified as) - change template # to D2753-3T1 (Not -IT1) 	J	06-03-14	1	VB 06-03-14	06-03-14

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

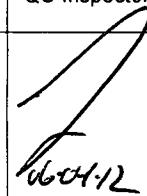
Date: Wednesday, 2/15/2006 3:50:34 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: LUG BRACKET
Job Number: 25867		Part Number: D27353
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP  <i>J 06-04-20</i>
Comment: INSPECT WORK TO CURRENT STEP		
7.0	PACKAGING 1	PACKAGING RESOURCE #1  <i>(20)</i>
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: WS21 <i>CPL 06-04-18</i> <i>(20)</i>		
8.0	DC	DOCUMENT CONTROL  <i>06/04/20</i>
Comment: DOCUMENT CONTROL Inspection Level 21		
Job Completion		 <i>✓ 06-04-19</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

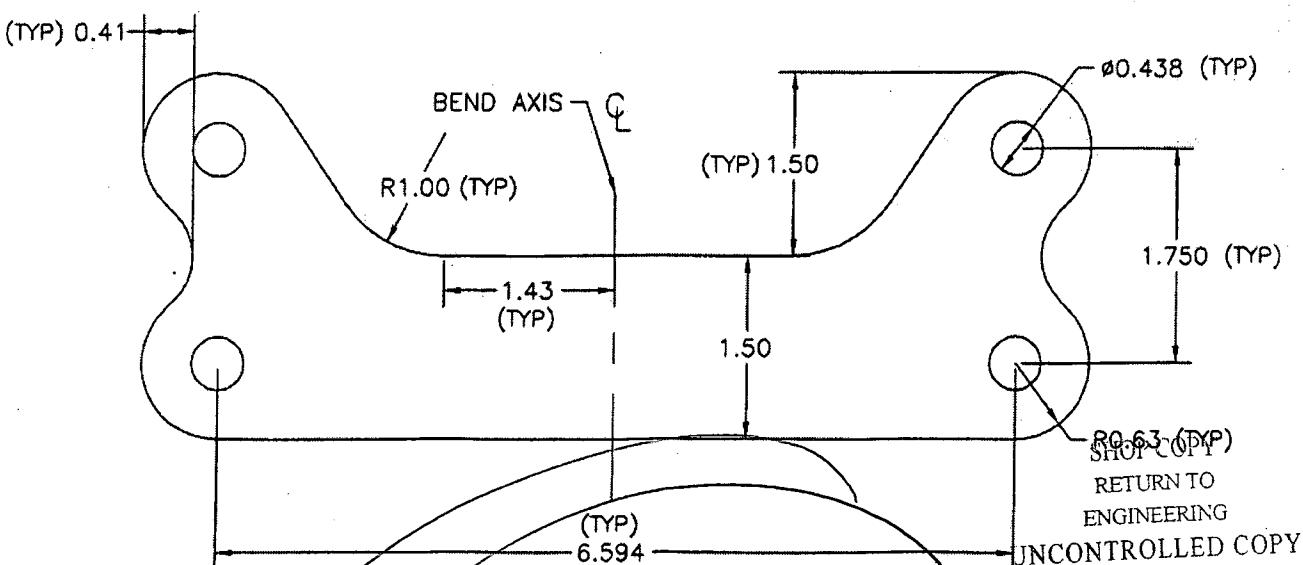
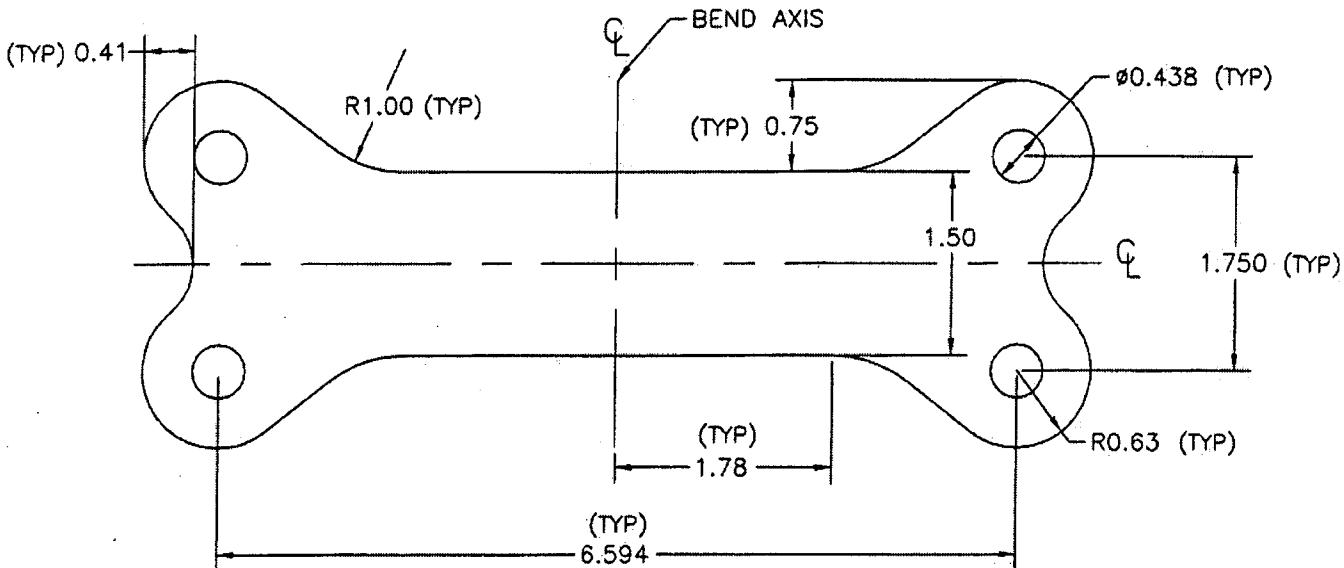
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/04/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/04/12	S.O	1 part scrap. Bends way out of tolerance on the ends & shape doesn't fit skid tube welding J.Y.		Scrap: destroy	 06/04/12	 06/04/12	 06/04/12	 06/04/12

NOTE: Date & initial all entries

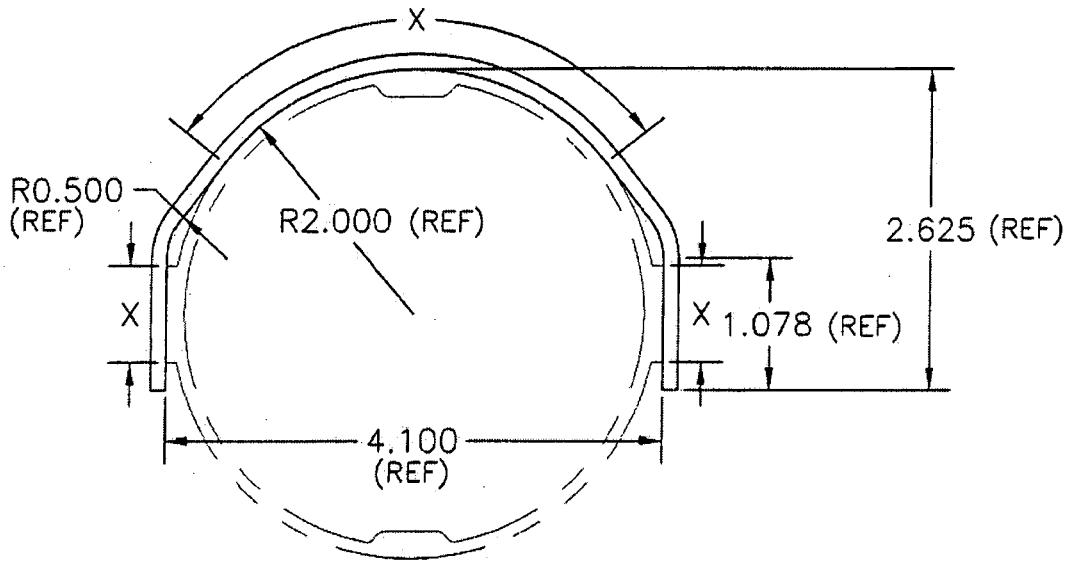
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
<i>cp</i>	<i>KE</i>	D2735	SHEET 1 OF 2
DATE	TITLE	SCALE	
98.12.14	LUG BRACKET	2.3	
A	97.12.14	NEW ISSUE	
B	98.10.23	UPDATE MATERIAL (TSR A1114)	
C	98.12.14	REMOVE TOOLING HOLES (TSR A1040)	

RELEASED
 98.12.14 DS


DART

DESIGN <i>PF</i>	DRAWN BY <i>PF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735
DATE 98.12.14	TITLE LUG BRACKET	REV. C SHEET 2 OF 2 SCALE 2:3

RELEASED
98.12.14 DSD2735-1 AND D2735-3 BEND DETAIL

D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.125 THICK (11 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25867



New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 375 9999 / 375 8111 Auckland
(09) 235 8089 / 235 9535 Waikato
Fax: (09) 375 8999

TEST CERTIFICATE

Ref: 5746/25194

Reissued 1/12/2005

CUSTOMER	Wilkinson	SPECIFICATION ASTMA1008 CS Type A													CERTIFICATE No	TC122435								
CUSTOMER O/N	99-21N-963	PRODUCT CRA WIDE COIL													PAGE	1 of 1								
MILL O/N	507683	DIMENSIONS 0.114" x 48" x Coil													DATE	29 November 2005								
CHEMICAL COMPOSITION PERCENT																								
PACK NUMBER	HEAT NO	C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE()	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH (feet)
		x100			x1000			x10000		x100		x100		x100		180°		G.L.=	HRB	()				
R9-471775-00	644609	4	TR	20	8	11	11	17	23	1	6	1	1				Good				51		794	
R9-471776-00	644609	4	TR	20	8	11	11	17	23	1	6	1	1				Good				51		682	
R9-471777-00	644609	4	TR	20	8	11	11	17	23	1	6	1	1				Good				54		768	
R9-471778-00	644609	4	TR	20	8	11	11	17	23	1	6	1	1				Good				54		640	

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (B)=50mm	PLASTIC STRAIN RATIO (r) (A)=r0 (B)=r90	IMPACT TEST (A)=r0 (B)=(r0+r90+2r45)/4	(C)=5mm x 5mm (D)=2.5mm x 10mm (E)=5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/8 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15 (C)=C+Mn/6+Si/24 (D)=
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WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Batish Misra*
QC METALLURGIST